DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028913
Date Inspected: 14-Dec-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name: Andrew Keech

CWI Present:	☑ Yes	☐ No						
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: SAS Tower

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Electro Slag Weld (ESW) 'G' weld joint #S-045 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at location Y=8030mm due to UT detected defect. The ABF personnel have resumed the exploratory excavation from 20mm deep where ABF personnel have left off yesterday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Andrew Keech was observed performing Magnetic Particle Testing (MT) on the following various depths with two noted linear indications. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 23mm with same result. The excavation was completed up to this point and will resume from this point at the next scheduled shift.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

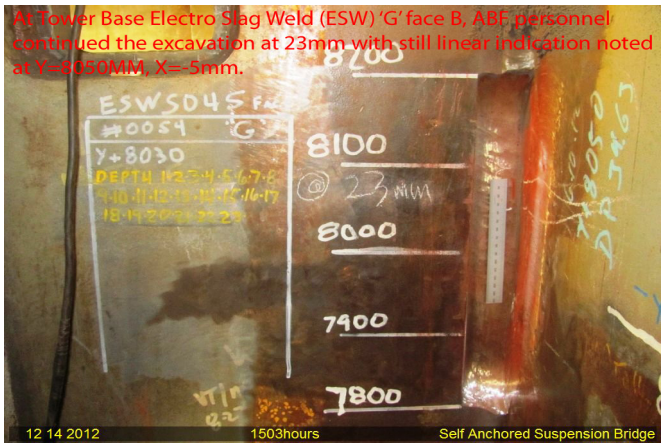
1. 21mm in depth – one 22mm long linear indication noted at Y=8050mm, X=-5mm

2. 22mm in depth – one 30mm long linear indication noted at Y=8050mm, X=-5mm and one 2mm long linear indication at Y=7930mm, X=-12mm.

3. 23mm in depth – one 30mm long linear indication noted at Y=8050mm, X=-5mm and the other 2mm long linear indication has been removed.

The exploratory excavations at this location will be continued on the following shift.

At Tower Base Electro Slag Weld (ESW) 'V' weld joint #W-043 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at various Y locations; Y=1030mm, Y=1055mm, Y=1090mm, Y=1100mm and Y=1130mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation at 63mm deep wherein ABF QC Jesse Cayabyab wants the width of the weld cover (35mm wide) to be the same width at the bottom of the excavation at 63mm. The width of the excavation at 63mm deep was originally measured at 25mm. The personnel were noted using only the disc grinder in widening the width of the excavation. The widening of the excavation was completed and ABF QC commence the MT which was not completed during this shift.



Summary of Conversations:

No significant conversation today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural

Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer